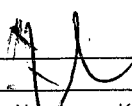
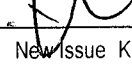


Date: Thursday, 12/07/2007 7:57:05 AM
User: Linda Lacelle









Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 427 "I" BEAM
Job Number : 33518	
Estimate Number : 10369	
P.O. Number :	Part Number : D2792130
This Issue : 12/07/2007 S.O. No. :	Drawing Number : D2792 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 24030	Material :
Written By : 	Due Date : 19/07/2007 Qty: 60 Um: Each
Checked & Approved By : 	
Comment : Est. A 98.11.09 New Issue KS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
  <p>Comment: PURCHASING Issue P/O: <u>4151</u> <i>C 207/07/12</i> a) Extrude as per Dwg D2792 b) Material: 6061-T6 (QQ-A-200/8) c) Tool: MS-19248 d) Material certification is required. e) 130 is equal to 130.0"</p>		
2.0	D2792130P	EXTRUSION
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) EXTRUSION</p>		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
  <p>Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached</p>		
4.0	PG	PURCHASING
  <p>Comment: PURCHASING Issue P/O: <u>75</u> 1-Send a sample for pull testing 2-Attach test report to W/O</p> <p><i>QC 5</i> <i>N/A</i> <i>1707-23</i> <i>75</i> <i>60</i> <i>75</i></p>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-07-23	4.0	Not necessary. Pull test is done upon material certification per ASTM B-221, remove this step, perm. change	EE	07.07.24		07-07-23	07-07-23	
07-07-23	5.0	QC 6 only. Perm. Change.	EE	07.07.24		07-07-23	07-07-23	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/07/2007 7:57:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 427 "I" BEAM

Job Number: 33518

Part Number: D2792130

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



2007-23 75



Comment: DIMENSIONAL CHECK

Inspect Level 6

Check Test Report to Dwg D2792 for compliance

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

Job 7-8-13

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2007-08-13

Job Completion



2007/08/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

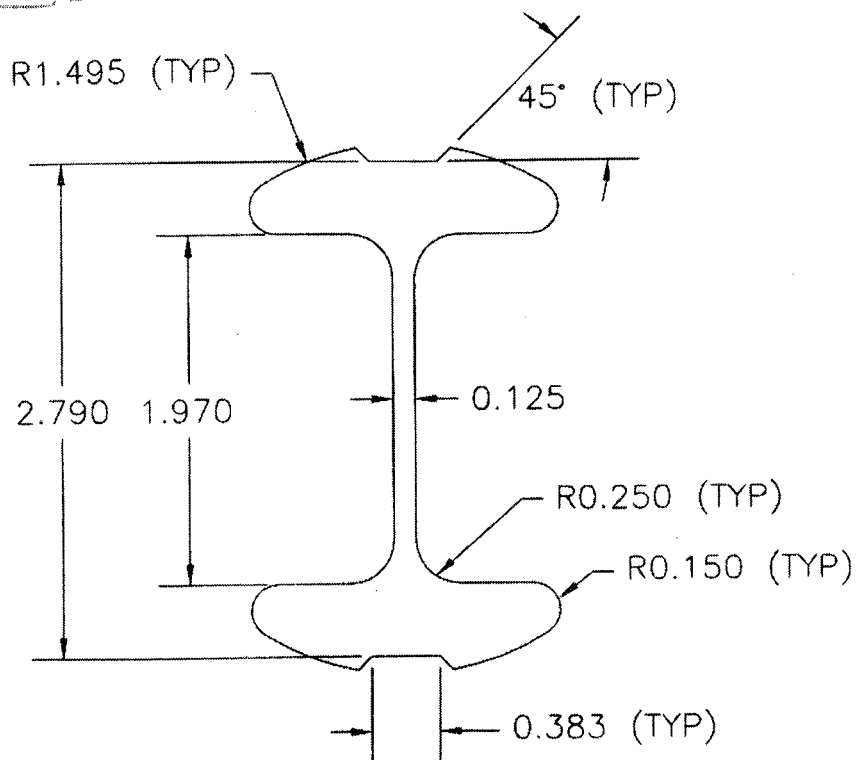
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>RAH</i>	DRAWN BY <i>RAH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>CA</i>	DRAWING NO. D2792	REV. A SHEET 1 OF 1
DATE 98.08.13		TITLE EXTRUSION	SCALE 1:1
A	98.08.13	NEW ISSUE	
A1	01.04.17	ADD NOTE #7 <i>CP</i>	

RELEASED
98.08.25 DS



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
3. BREAK ALL SHARP CORNERS 0.010 MAX.
4. NO ID TOOLING MARKS.
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.

7. PART NUMBER IS D2792-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2792-145 IS 145" LONG)

w/o
33518
7
070723



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer: DART AEROSPACE LTD

Adresse / Address: 1270 ABERDEEN STREET
HAWKESBURY ONT.
K6A 1K7

Commande Indalex / Indalex order #: 7071041

Bon de commande / Purchase order #: 4151

Matrice / Die #: MS 19248 Description: N/A

Alliage & trempage / Alloy & temper: 6061 T6

Contrôle / Control #: 2222

Coulée / Cast #: 40861

2792-136

	Min. requis Min. required	Résultat actuel Actual Results
Tension ultime Ultimate stress (psi)	38 000	42181
Contrainte élastique Yield stress (psi)	35 000	39429
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (Hre) Rockwell E Hardness (Hre)	88 @ 100	83

Composition chimique typique / Typical chemical composition:

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.40	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,

date: 2007-07-18

Yours truly,

Mark Oliver Kokiong
Technicien de la qualité
Quality technician

Indalex Limited

